

Work Order ID 63915

Thursday, November 18, 2010 3:57:54 PM



Page 1

Item ID: D4022-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Transfer Pump Assembly

Stop



Start Date: 11/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 10-11-19

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4022	A

100 0.00



Small Fab

Memo

0.00

Small Fab

assemble as per dwg D4022

Metal set A4 batch:

M116173 = 7 m.l 10/12/15

(3X)

110 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

8/10/12/17

(X3)

120 Identify as per dwg & Stock Location: 113 0.00



Packaging

Memo

0.00

Packaging

10/14/17 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/2010

U 10.12.17

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63915

Parent Item: D4022-041

Parent Item Name: Fuel Transfer Pump Assembly









Start Date: 11/19/2010

Required Date: 12/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4022-1  Fuel Transfer Pump		Manufactured	No			100	Each	0.0000	1	2			
						363942				3x		m.p 12/12/15	
D4022-5  Thermal Switch		Manufactured	No			100	Each	5.0000	1	2			
						B 55518				3x		m.p 12/12/15	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ENG	5							
					55518	5							
AN815-6D  Union-M-Flare		Purchased	No			100	Each	16.0000	2	4			
												m.p 12/12/15	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST329	16							
					114988 ✓	16				6x			
MS29512-06  O-RING		Purchased	No			100	Each	13.0000	2	4			
												m.p 12/12/15	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST294	13							
					114742 ✓	13				6x			

W/O:		WORK ORDER CHANGES					
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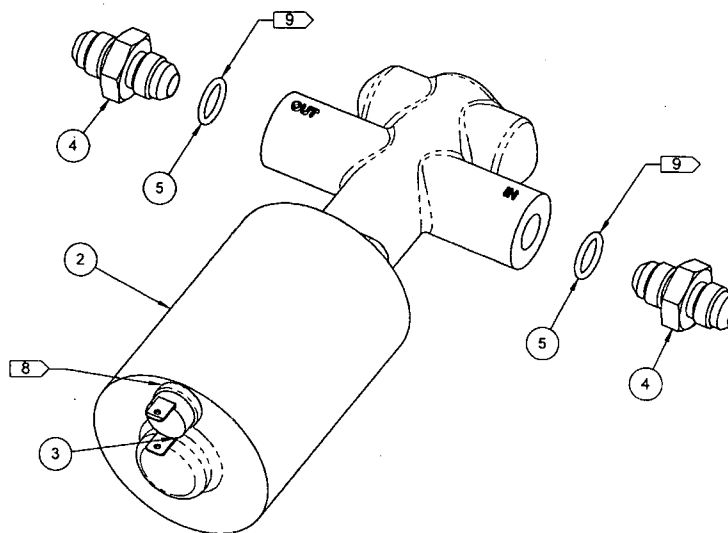
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4022-041	FUEL TRANSFER PUMP ASSEMBLY	A8150-B1-JCA
2	1	D4022-1	FUEL TRANSFER PUMP	
3	1	D4022-5	THERMAL SWITCH	
4	2	AN818-6D	FITTING, UNION	
5	2	MS29512-06	O RING	



D4022-041 FUEL TRANSFER PUMP ASSEMBLY

63915

RELEASED
2010-05-05
WMD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4022-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.61 lbs
- 8) ATTACH D4022-5 THERMAL SWITCH TO D4022-1 FUEL PUMP IN LOCATION SHOWN USING METALSET A4
- 9) LUBRICATE O-RING WITH ULTRACHEM ASSEMBLY FLUID #1, FUEL-LUBE, MOLYKOTE 55 O-RING GREASE OR EQUIVALENT

A		NEW ISSUE		10.04.16	
REV.		DESCRIPTION	BY	DATE	
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	10.04.16				

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4022	REV. A
TITLE FUEL PUMP	SHEET 1 OF 4
SCALE NTS	
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Dart Aerospace Ltd

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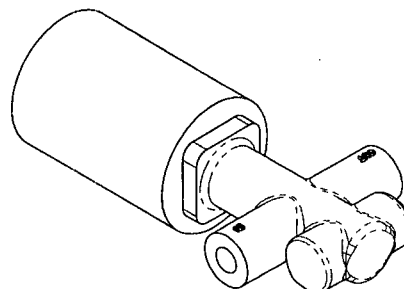
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4022-1	REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



#63915

DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	OPERATING VOLTAGE	FLOW (GPH)	OUTPUT PRESSURE (PSI)	TEMPERATURE RANGE
D4022-1	WELDON	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F
	AEROSPACE ACCESSORIES	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F

D4022-X FUEL TRANSFER PUMP

RELEASED
2010-05-05
JW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.6 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D4022	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		FUEL PUMP	SCALE
DE APPR.			NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

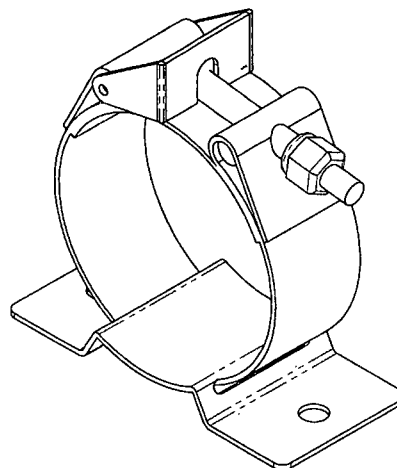
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4022-3	REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS MOTOR SIZE (ϕ)
D4022-3	WELDON	TC 250-100	STAINLESS STEEL	2.5
	AIRCRAFT SPRUCE AND SPECIALTY	05-00021	STAINLESS STEEL	2.5
	AEROSPACE ACCESSORIES	TC 250-100	STAINLESS STEEL	2.5

D4022-X FUEL PUMP MOUNTING BRACKET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE LTD
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CHECKED		DRAWING NO. D4022
MFG. APPR.		REV. A
APPROVED		TITLE FUEL PUMP
DE APPR.		SCALE NTS
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RELEASED
2010-05-05
MP

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

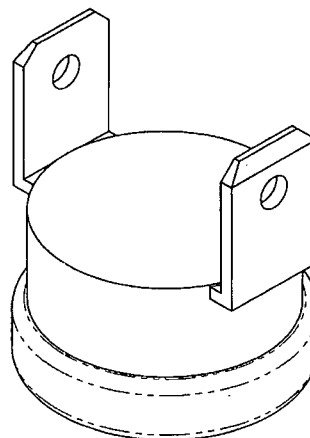
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4022-5	REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	ALTERNATE PART NUMBER	TEMPERATURE WHEN SWITCH OPENS
D4022-5	FARNELL	1006847	3775628	125°F
	HONEST-WELL	T23A125BSR2-15	3775628	125°F
	NEWARK	98K1992	3775628	125°F

D4022-X THERMAL SWITCH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4022	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FUEL PUMP	NTS
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